



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3183-3

Job Sheet 192441



Part No: D3183-3

Job Qty: 4 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 4/16/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 14703

Note: DWG REV C1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	4/16/19	4/16/19	0.00	0.80	Bandsaw - 1		
110	HAAS 4 Axis - B4B	4 pcs	4/16/19	4/16/19	0.00	18.18	HAAS - 1 - B4B		KT 19/04/08
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	4/16/19	4/16/19	0.00	0.00	QC 2 - 1		KT 19/04/08
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		



Container No: S169340



Part: D3183-3

Job No: 192441

Serial No/Batch: S169340

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/03/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130	QC 8	4 pcs	4/16/19	0.00	0.00	QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	mm 19/04/08
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
170	QC 21 - SA	4 pcs	4/16/19	0.00	0.00	QC 21 - SA - 21	
						QC 21 - SA - 70	
						QC 21 - SA - 53	

160 Packaging 3 IA and stock

PKg 3-6

DAS
28
9-89

DAS
21
9-89

APR 12 2019

Part Op 100 - (Bandsaw)

Descriptions: 110 - (HAAS CNC Vertical Machine)

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	2 ft (.5 ea)	100-Bandsaw - 1	EM 127895

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.500X2.250	2	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.190inches $\pm$ 0.030	0.220 0.160	Radius	
2	Bracket	0.063inches $\pm$ 0.010	0.073 0.053	Radius	
3	Bracket	0.182inches $\pm$ 0.010	0.192 0.172		
4	Bracket	0.070inches $\pm$ 0.010	0.080 0.060		
5	Bracket	0.100inches $\pm$ 0.010	0.110 0.090		

6	Bracket	0.201inches $\pm$ 0.010	0.211 0.191	Diameter
7	Bracket	0.100inches $\pm$ 0.010	0.110 0.090	
8	Bracket	0.182inches $\pm$ 0.010	0.192 0.172	
9	Bracket	5.320inches $\pm$ 0.030	5.350 5.290	
10	Bracket	5.036inches $\pm$ 0.010	5.046 5.026	
11	Bracket	2.120inches $\pm$ 0.010	2.130 2.110	
12	Bracket	1.290inches $\pm$ 0.010	1.300 1.280	
13	Bracket	0.365inches $\pm$ 0.010	0.375 0.355	
14	Bracket	0.218inches $\pm$ 0.010	0.228 0.208	
15	Bracket	1.030inches $\pm$ 0.010	1.040 1.020	
16	Bracket	1.900inches $\pm$ 0.030	1.930 1.870	
17	Bracket	1.012inches $\pm$ 0.010	1.022 1.002	
18	Bracket	0.201inches $\pm$ 0.010	0.211 0.191	Diameter
19	Bracket	0.100inches $\pm$ 0.010	0.110 0.090	
20	Bracket	0.786inches $\pm$ 0.010	0.796 0.776	
21	Bracket	0.392inches $\pm$ 0.002 - 0.000	0.394 0.392	Diameter
22	Bracket	0.190inches $\pm$ 0.030	0.220 0.160	Radius
23	Bracket	3.954inches $\pm$ 0.010	3.964 3.944	
24	Bracket	0.162inches $\pm$ 0.010	0.172 0.152	
25	Bracket	0.190inches $\pm$ 0.030	0.220 0.160	Radius
26	Bracket	0.250inches $\pm$ 0.030	0.280 0.220	Radius
27	Bracket	4.260inches $\pm$ 0.030	4.290 4.230	
28	Bracket	2.080inches $\pm$ 0.030	2.110 2.050	
29	Bracket	1.155inches $\pm$ 0.010	1.165 1.145	
30	Bracket	0.162inches $\pm$ 0.010	0.172 0.152	
31	Bracket	0.360inches $\pm$ 0.010	0.370 0.350	
32	Bracket	0.615inches $\pm$ 0.010	0.625 0.605	
33	Bracket	0.435inches $\pm$ 0.010	0.445 0.425	
34	Bracket	0.200inches $\pm$ 0.010	0.210 0.190	
35	Bracket	0.381inches $\pm$ 0.010	0.391 0.371	
36	Bracket	0.032inches $\pm$ 0.010	0.042 0.022	

Plex 3/25/19 11:29 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					